

Date: Monday, 9/10/2007 1:18:58 PM
 User: Kim Johnston

Process Sheet

Split 3

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM
Job Number	34475		
Estimate Number	12882		
P.O. Number	N/A	Part Number	D3560042
This Issue	9/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3560 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	32645	Drawing Revision	B/C
Written By		Material	N/A
Checked & Approved By		Due Date	9/17/2007
Comment	Est Rev:A New Issue 07.05.24 EC	Qty:	83
Um:			12
Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
Comment: Qty.: 1.4648 f(s)/Unit Total : 17.5770 f(s)		
6061-T6 Bar 0.50" x 5.0"		
Batch: N105646		<i>JWL 07/09/20 1.2</i>
2.0	BAND SAW	BAND SAW
Comment: BAND SAW		
Cut blanks 16.750" long		
<i>JWL 07/09/20 1.2</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1- Mill as per Folio FA694 Rev: A & Dwg D3560 Rev: C		
2-C'sink 0.196" hole on manual mill as per dwg D3560		
3-Deburr per dwg D3560		<i>JL 07/09/21</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
		<i>JL 07/09/21 1.2</i>



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Seq. #: Machine Or Operation:

Description :

6.0 D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

PLATE

334478(3)

11/07/10

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

11/07/10-29(3) 11/07/10-10

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/10-29(3) 11/07/10-12

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-29(3)

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FAT 07/10/01(3)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

11/07/01(3)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 07-11-01(3)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MA

11/07/01(3)



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Part Number: D3560042

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

Darlene

Job Completion



U 9/11/02

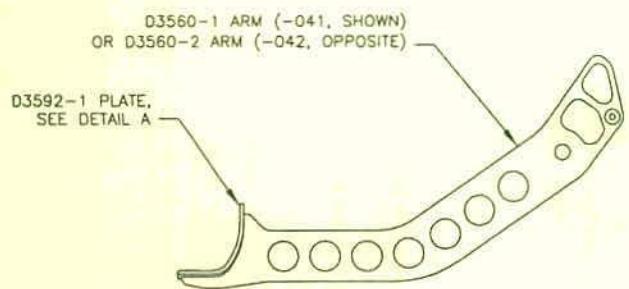
DART AEROSPACE LTD	Work Order:	34475
Description: Arm	Part Number:	D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

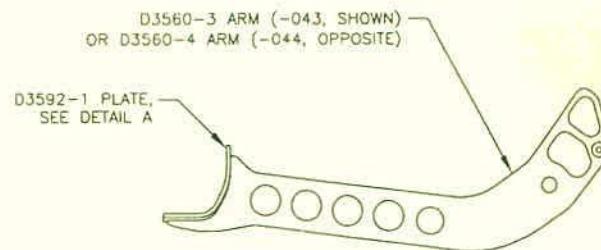
First Article Prototype

Measured by:	<u>JL</u>	Audited by:	<u>SC</u>	Prototype Approval:	N/A
Date:	<u>04/07/21</u>	Date:	<u>04/07/21</u>	Date:	N/A

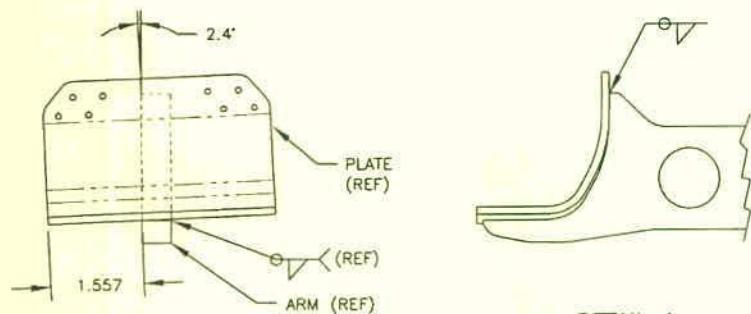
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	EE



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 01B UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3560	SHEET 1 OF 3
DATE		TITLE	SCALE
07.06.19		ARM WELDMENT	1:4

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